

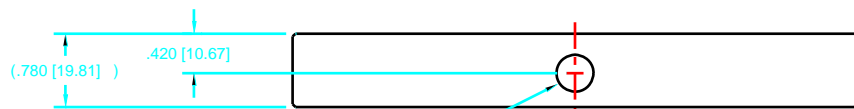
(C)

PLOT SCALE:

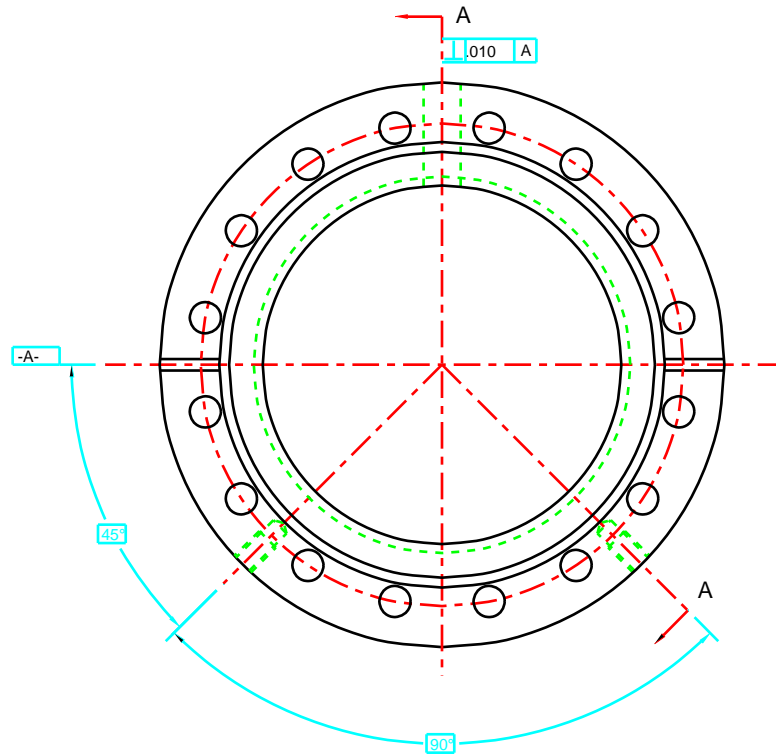
1=1

DWG. SCALE: 1

A13697



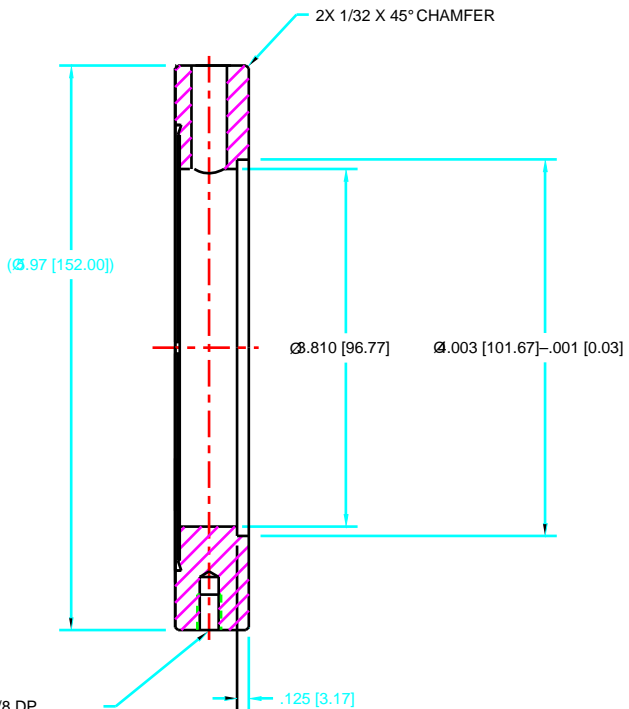
Ø86 THRU



## NOTES:

1. MAKE FROM MDC'S CAT. #110025  
SILICONE AND SULPHUR-BASED CUTTING FLUIDS  
IS PROHIBITED. USE ONE OF THE FOLLOWING:  
2. WHEN MACHINING VACUUM PARTS, USE OF  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
3. THIS IS A UHV PART, ELECTROPOLISHING  
IS NEEDED BEFORE WELDING. PRIOR TO  
ELECTROPOLISHING, THE PART NEEDS TO GO  
THROUGH A MULTIPLE STEP CLEANING PROCESS  
INVOLVING DEGREASING, WASHING AND DRY  
NITROGEN BLOW DOWN.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV  
PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [ ] ARE MILLIMETERS AND  
FOR REF. ONLY

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				



2X 1/4 - 20 UNC 2B X 3/8 DP.

SECTION A - A

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGULAR				
.X - .03 [.7620] - .25				
.XX - .01 [.254] - .125				
.XXX - .005 [.127] - .125				
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER <b>A13697</b>		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
DRAWN BY <b>MUSCIA</b>	DATE <b>9/27/93/</b>	CHIEF DESIGN ENGINEER	DATE	TITLE
CHECKED BY		GP LEADER		<b>ADVANCED PHOTON SOURCE</b>
DESIGNER <b>MUSCIA</b>		PROJECT MGR.		<b>I.D. FRONT END</b>
RESPONSIBLE ENGINEER		APPROVED/RELEASED		<b>4" I.D. BE WINDOW</b>
MATERIAL <b>SEE NOTE #1</b>		DRAWING NUMBER <b>P4102010109-210004-00</b>		
SCALE <b>1:1</b>		SIZE <b>C</b>		
SHEET <b>1 of 1</b>				